

indicated by the dotted lines 10-10 they will have the configuration shown in Fig. 10 of the drawings.

The die 25 will give the materials 17, 21 the final correct configuration they will have as strips 10 and 11, respectively, in the unitary plastic strip. As a result of this operation also, the combined plastic materials forming the composite strip will have an "as extruded" surface appearance in their hardened condition, as distinguished from the surfaces provided by press-polishing, machining, skiving, or otherwise treating the plastic material. As the composite strip leaves the die 25, the plastic materials are air cooled and at a place spaced from such die, the strip formed thereby is fed into the field of action of cutting instrumentalities 26 which while the strip moves continuously therethrough, chops the strip into predetermined lengths 27. A twenty-six inch length of the type of strip shown in Fig. 1 of the drawings will provide sufficient material for eight frames, whereas sixteen or eighteen frames may be obtained from a fifty-two inch length thereof. The manner in which such frames may be cut out of the strip lengths 27 is indicated in Fig. 3 of the drawings while Fig. 4 indicates the manner in which the temples for such frames may be cut out of the strip lengths. The spectacle frames and temples may be cut from the strip lengths 27 by feeding the latter to a suitable stamping machine of known construction, or by cutting such spectacle parts from the strips in other ways known to the art.

It will be understood that the strip formed as aforesaid may have a width equal to the combined width of a plurality of the strips shown in Fig. 1. In the production of such a strip, the conduit 23 would be provided with a plurality of openings 30 to deposit a plurality of spaced strips of the molten plastic material 21 upon the stream of molten plastic material 17. The resulting cooled strip may then be cut longitudinally as by the revolving knives 28 in Fig. 6 into a plurality of separate strips such as shown in Fig. 1 before feeding the processed material to the cutting mechanism 26. The strip shown in Fig. 1 of the drawings may also be cut longitudinally by the knives 28 to provide two strips of the configuration shown in Figs. 2 and 3 of the drawings and which are then chopped into the desired lengths. The strip of Figs. 2 and 3 can, of course, be made originally in the form shown according to the method described with respect to the strip of Fig. 1 by making the obvious necessary changes in the various material discharge openings.

Instead of forming the strip 11 as a single strip in the longitudinal center of the base strip 10, the former may be formed as two divided strips 11', 11' along the longitudinal side edges of the strip 10' as illustrated in Fig. 13 of the drawings. In the construction of the strip of Fig. 13 it is preferred that the color of the strips 11', 11' fade into the longitudinal central portion of strip 10'. Accordingly, the strips 11', 11' will have their greatest thicknesses at the side edges of strip 10'. It is obvious, however, that such condition may be reversed to obtain a different desired color effect.

Figs. 11 and 12 illustrate two further constructions that may be made and in which the longer sides of the triangularly-shaped strips 35 and 36 are joined with the top surfaces of the base strips 37 and 38, respectively, so that the shorter angularly disposed sides of such strips extend upwardly from and form apexes above such top surfaces. In the construction of Fig. 11, the base strip 37 has a ridged top surface and the triangularly-shaped strip 35 has width equal to that of such base strip so that the gradient density material formed by such strips has a gradual changing color effect throughout its entire width. Thus, if strip 37 is made of clear plastic material and strip 35 of colored plastic material, the gradient density material will have the greatest density of the color of strip 35 along its longitudinal center and such density of color will fade out gradually towards the side edges of

such gradient density material. In the construction of Fig. 12, the strip 36 is narrower than the base strip 38 to provide a color effect which is somewhat similar to that produced by the composite strip of Fig. 1. It will be noted also in connection with the construction of Fig. 12 that the top surfaces of the longitudinal edge portions 39, 39 of the base strip 38 are inclined so that they are in the same plane with and form a continuation of the upper inclined surfaces of the triangularly-shaped strip 36.

While I have hereinabove illustrated and described preferred methods of manufacturing spectacle frames in accordance with the invention, it will be apparent to those skilled in the art that various changes and modifications may be made therein without departing from the spirit of the invention or the scope of the appended claims. Thus, instead of making the second strip 11 in Fig. 1 of triangular cross-sectional area, such strip may be made of any other suitable cross-sectional configuration, such as semi-elliptical. Also the strip 11 need not conform in cross-sectional area exactly to the cross-sectional area of the depression, but may have a cross-sectional area differing from that of the latter both in configuration and size. Also, when it is stated that the edges of such a strip 11 are practically infinitesimal in thickness, it will be understood that such edges will have a measurable thickness. It is also within the contemplation of the invention to construct the strip 11 so that the edges thereof will have a fairly substantial thickness. It will be apparent also that the strips combined to form the composite strip of this invention may have other configurations than those hereinabove described and illustrated in the drawings to obtain different gradient color effects. With regard to those composite strips produced in the manner above described, it is of interest to note that a reversal of the plastic material superposed on the base strip as in the strip of Fig. 1, usually occurs when the latter is formed as a flat strip having a substantially rectangular cross-sectional configuration. When, however, the base strip is made in other forms, such as the wedge-shaped forms shown in Figs. 11 and 12, this reversal of the material superposed on the base strip does not take place and the latter solidifies on the base strip in substantially the form in which it is deposited thereon. The above described method of making the composite strips may also be slightly modified to produce still further variations in the forms of the strips. Thus, instead of having the conduit 20 curve under the conduit 23 at the place of intersection thereof, the pipe section 23' and block 29 may be formed to cause the conduit section 20'' to curve up and over the pipe section 23' and to discharge into the upper portion of conduit 24. In the use of this arrangement therefore, the plastic material 17 to form the base strip of the product is discharged from section 20'' upon the stream of molten plastic material 21 feeding through the opening 30 of pipe section 23'. It will also be apparent that the pipe section 23' and block 29 may be formed so that conduit section 20'' may be constituted of two passages extending over and under the pipe section 23' and discharging the plastic material 17 into the entry end of conduit 24 above and below the opening 30 in pipe section 23'. In the use of such a construction, the plastic material 21 discharging through opening 30 will be sandwiched between the material 17 coming from the dual discharge ends of pipe section 20''. By changing the configurations of such dual discharge ends and the opening 30 a number of additional forms of the composite strip may be attained.

I claim:

1. The method of making spectacle parts, comprising forming a light-transmittible, composite, rectilinear strip having substantial rigidity at ordinary temperatures by uniting to a base layer of light-transmittible plastic material of a given color and of substantial rigidity at